

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013515**Date Inspected:** 20-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Yuan Hua.	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard:

SEG 9EW:

During random inprocess visual inspection of this segment, this QA Inspector observed ZPMC personnel repair welding of various fillet welds joining floor beam to side panel. Welder was identified as 045133. Welding process is identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair-1.

SEG 9DW:

This QA Inspector observed the following work in progress:

Repair welding of weld nos: SEG055D-PP81-128 & 164. Welder was identified as 037840. Welding process was identified as SMAW. This QA verified the Welding Repair Report (WRR): B-WR-12046 Rev-0. ZPMC QC was

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identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G (3F)-Repair-1.

SEG 10BE:

This QA Inspector observed the following work in progress:

SMAW of weld joint PP88-OBE10D-015/016. Welder is identified as 054013. ZPMC Quality Control (QC) is identified as Wang Chang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

10AE:

This QA Inspector observed the following work in progress:

SMAW of weld joint SEG060D-PP86-049 & 013. Welder is identified as 050232. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

SMAW of weld joint SEG060E-PP88-074. Welder is identified as 050232. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

SEG 9EE, SEG 11CE, SEG 11BW, SEG 11AE, SEG 11BE, SEG 11CW:

This QA Inspector observed that no significant work was being performed on the above mentioned segments, at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
